

Work Order ID 128092

February-24-15 2:28:31 PM

repair

Ship March 13

128092

Page 1

Item ID: D350-636-101

Revision ID:

Item Name: Toe Step

Start Date: 1/06/15 Start Qty: 30.00

Required Date: 1/06/15 Req'd Qty: 30.00

Reference:

9350-636-101
B128092
REV. A

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3487	Rev A

100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD350-636-101 CHG001.								

15103131

110		0.00							
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110									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg *** D3487-1***								
	Dwg Rev: A								
	Prog Rev: A								
	2-Deburr if necessary								

60601-100

36 0 Jm15-2-25

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Item ID: D350-636-101

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Toe Step

Stop ***NS2***

Start Date: 1/06/15 Start Qty: 30.00

30

Cust Item ID:

Required Date: 1/06/15 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

36

Ø

Jm15-2-25

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

36

DAS
38
9-89

FEB 26 2015

150

NC BRAKE

0.00

150

Brake NC

Memo

0.00

Brake NC

Form as per Dwg D3487

33

DAS
30
9-89

05/03/02

PTO

DQA:

Date:

16/05/05



QA Closed:

Date:

15/04/30

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>128092</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D380-636-011</u>		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. <u>15-4838</u>		Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material	15/05/02	150	3	3 part crack when forming P.C. material. 337 307 3042	5 15/04/22 932042	Scrap & destroy no replace 3x	DAS 30 9-89 15/03/02	30 9-89 MAR 03 2002	PD 15-03-03
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☒ Bend ☐ BOM/Route ☒ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Item ID: D350-636-101 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Toe Step
 Start Date: 1/06/15 Start Qty: 30.00 *30* Cust Item ID:
 Required Date: 1/06/15 Req'd Qty: 30.00 *30* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
160						33			
QC	Memo	0.00							
Quality Control									
170	Chemical Conversion Coat per QSI005 4.1	0.00							
170						33x	DAS 28 9-89	MAR 24 2015	
HandFinish	Memo	0.00							
Hand Finishing									
180	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
180	M124808					33	15-3-20		DAS 34 9-89
Powdercoat	Memo	0.00							
Powder Coating									

START TIME: 8:10 FINISH TIME: 8:40

Std 30-31/03 Avic!

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Item ID: D350-636-101 Accept *N900040100* Setup Start *NS1*
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 Required Date: 1/06/15 Req'd Qty: 30.00 *30* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <u>M131550</u> Memo	0.00				<u>33</u>	<u>18/03/30</u>		
200 *200* QC Quality Control	QC3- Inspect Part Finish Memo	0.00				<u>(33)</u>			DAS 38 9-89 MAR 30 2015
210 *210* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D350-636-101 Location: <u>16120</u> PPP Rev: _____	0.00				<u>33</u>	<u>18/03/31</u>	<u>31</u>	<u>31</u>

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Item ID: D350-636-101 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Toe Step
Start Date: 1/06/15 Start Qty: 30.00 ***30*** Cust Item ID:
Required Date: 1/06/15 Req'd Qty: 30.00 ***30*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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230	QC21- Final Inspection - Work Order Release	0.00							
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230

QC	Memo	0.00				MLJ		15-03-31	
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Quality Control

MLJ 5-03-27

Picklist Print

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Work Order ID: 128092

128092

Parent Item: D350-636-101

D350-636-101

Parent Item Name: Toe Step

Start Date: 1/06/15

Required Date: 1/06/15

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:A New Issue 06-03-03 JLM
11.03.15 now made in house DD verf:JLM

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.100		Purchased	No			110	sf	96.0000	0.7942	48			
M6061T6S 100										**	(32)	Jm15-2-25	
6061-T6 .100 Sheet													

Location

Loc Qty

Loc Code

MAT020

96

m128315

16

m129165

32

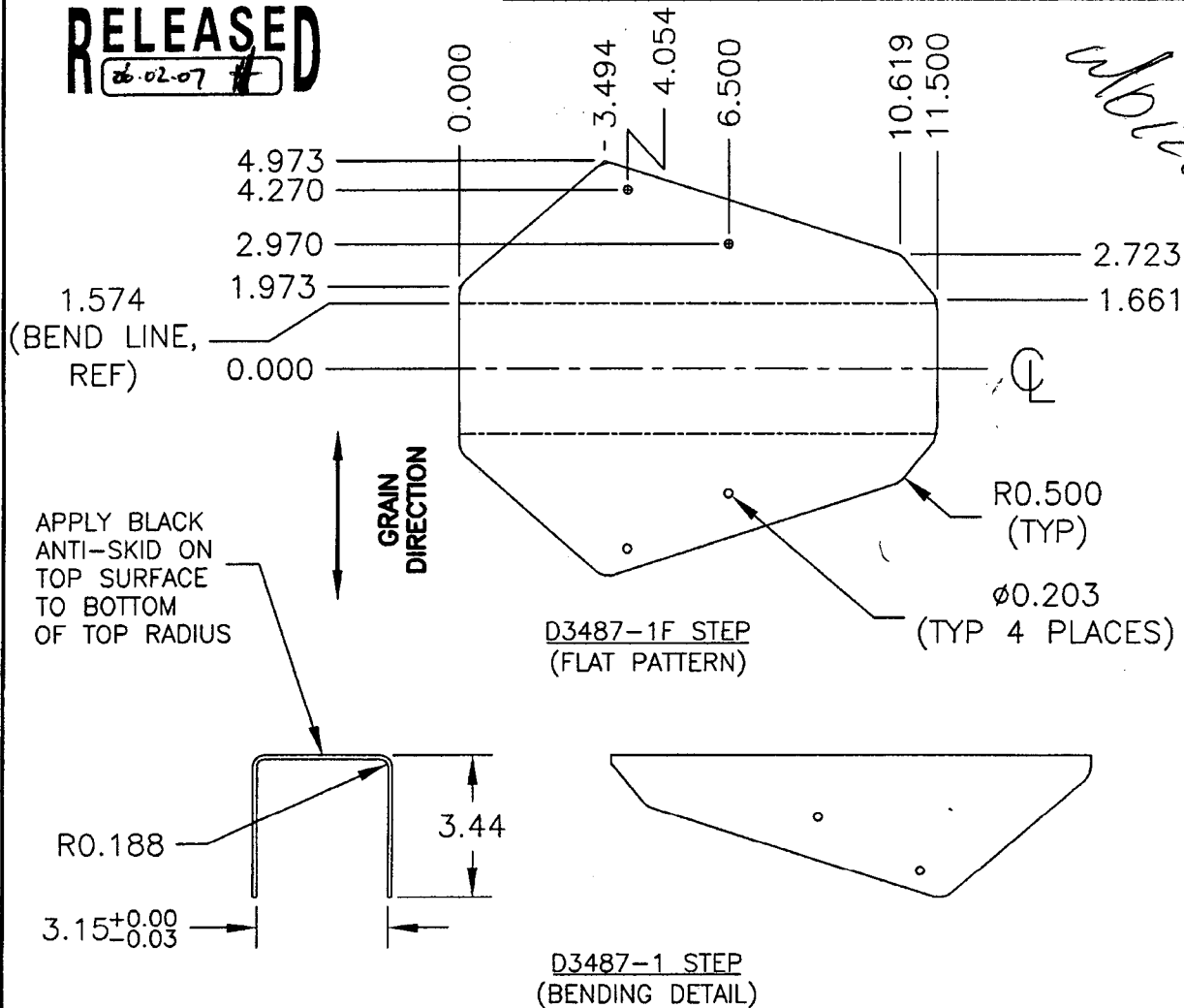
m131352

48

129165
~~129165~~

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3487	REV. A SHEET 1 OF 1
DATE 06.01.16		TITLE STEP	SCALE 1:4
A	06.01.16	NEW ISSUE	

RELEASED
26-02-07**D3487-1 STEP**

- 1) MATERIAL: ALUMINUM 6061-T6/T651 ALUMINUM (QQ-A-250/11) 0.100 THICK
(REF DART MATERIAL SPEC M6061T6S.100)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO TOP SURFACE PER DART QSI 005 4.4
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE
- 6) BREAK UNMARKED EDGES 0.005 TO 0.010 MAX

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